

Work Order ID 82791

April-10-12 7:55:09 AM

\*82791\*

Page 1

Item ID: D350-636-014

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Item Name: Skidtube RH

Stop \*NS2\*

Start Date: 10/04/2012 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 24/04/2012 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/04/10 Tooling:

Date:

Run Start \*NR1\*

QC:

Date: SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2750

F

D3492

C

100

0.00

\*100\*

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy blue file and type labels per PPP D350-636-014 CHG 006

12 06 25  
MLJ 12-6-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 82791****\*82791\***

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**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

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Item Name: Skidtube RH

Start Date: 10/04/2012 Start Qty: 1.00

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Cust Item ID:

Required Date: 24/04/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

110

0.00

**\*110\***

Skidtubes

0.00

Skidtubes

Memo

1- Pick D2600-3 Bent ✓

2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside  
AFT end per dwg D2750 ✓3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500",  
deburr. ✓4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade  
fitting ✓

5- Drill only two fwd step holes using DT9616. Ensure proper positioning. ✓

6- Drill pilot holes as per Dwg D2750 sheet 4 (D2750-4 details). Drill using drill,  
Jig DT8150 & DT8864A for first side only DT8864B for second side (detail B) ✓7- Clecko DT8864B on second side of tube and drill pilot holes for detail B.  
\*\*\*SECOND SIDE\*\*\* ✓8- Open up holes for SECTION AW-AW to 0.375" (2 holes per side) and blade  
fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750.  
Open holes for ground handling and detail T to 0.500" (8 holes per side) ✓9-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to  
0.297". ✓

10-Open up holes of Detail A to 0.297" (total of 2 holes per side) ✓

*Ext 12-04-25*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Revision ID:

Stop **\*NS2\***

Item Name: Skidtube RH

Start Date: 10/04/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 24/04/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp11-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left  
from bending as per QSI 004

A/R Aluminum Rod batch:

M20854 BE 12/04/25

12-Grind welds flush as per Dwg D2750

12-04-25

120

QC10- Inspect visual per QSI004- ground welds

0.00

**\*120\***

QC

Memo

0.00

Sizlor/26

Quality Control

130

QC5- Inspect part completeness to step on W/O

0.00

**\*130\***

QC

Memo

0.00

Sizlor/26

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Setup Start **\*NS1\***

Revision ID:

Item Name: Skidtube RH

Stop **\*NS2\***

Start Date: 10/04/2012 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 24/04/2012 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run Start <b>*NR1*</b>
	QC:	Date:	SPC (Y/N):	Date:	Stop <b>*NR2*</b>

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Chemical Conversion Coat per QSI005 4.1	0.00							
<b>*140*</b>									
HandFinish	Memo	0.00							
Hand Finishing									
150	QC3- Inspect Part Finish	0.00							
<b>*150*</b>									
QC	Memo	0.00							
Quality Control									

*Handwritten: 7/12/12 12-26*

*Handwritten: SAD B-05-01*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Skidtube RH

Start Date: 10/04/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 24/04/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

0.00

**\*160\***

Skidtubes

0.00

Skidtubes

Memo

Skidtubes

1-Open up holes section BE-BE 0.500" (4 per side) as per dwg D2750 ✓

2-Open holes section BC-BC 0.3125" (4 per side) ✓

3-Open up holes of Detail AB and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750. ✓

4-Chamfer holes of section BE-BE, BC-BC, AB and ground handling (welding instructions on sheet 11) ✓

5-Deburr and blow out all chips from inside of tube. Prepare tube for welding, remove alodine as required.

6-Bond web D2739 in place as per QSI 015

A/R Sikaflex-291

batch: 121221

exp. date: 2013-01-04

7- Weld spacers D3490-1, D3490-5 and D2743 as per dwg D2750 &amp; QSI004 (welding instructions on sheet 11)

A/R Aluminum Rod

batch: ~~121221~~

M120854

BG 12-05-02

8-Grind welds flush as per Dwg D2750

9-Spot face ground handling holes (total of 4 places per side) as per dwg D2750

10-Deburr holes

12-05-01

12-5-3

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Skidtube RH

Start Date: 10/04/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 24/04/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

170

QC10- Inspect visual per QSI004- ground welds

0.00

**\*170\***

QC

Memo

0.00

Quality Control

180

QC5- Inspect part completeness to step on W/O

0.00

**\*180\***

QC

Memo

0.00

Quality Control

190

Pressure Wash per QSI005 4.3

0.00

**\*190\***

HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

1 ~~6~~ 2P 12/05/07.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Skidtube RH

Start Date: 10/04/2012 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 24/04/2012 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

200

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

**\*200\***

Powdercoat

Memo

0.00

Powder Coating

START TIME: 2:40

OVEN TEMPERATURE: 320°F

FINISH TIME: 3:10

IX ✓

MA 12/05/07

W121134

210

QC3- Inspect Part Finish

0.00

**\*210\***

QC

Memo

0.00

Quality Control

Inspect for foreign object per QSI 024

IBH ✓

Y1 11/05/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 82791**

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**\*82791\***

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Item ID: D350-636-014

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**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Skidtube RH

Start Date: 10/04/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 24/04/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursTool ID Tool # Plan  
Code Accept Reject Reject Insp.  
Qty Qty Number Stamp

230

0.00

**\*230\***

HandFinish

HandFinishing

Memo

0.00

Hand Finishing

1-Install inserts as per dwg D2750

2-assemble o'ring as per dwg D3492 and apply o'ring lube

A/R 55-o'ring lube batch: 116 348

3-Assemble tube hardware as per dwg D2750

sikaflex batch: 121221 / 13/01

4-Inspect For Foreign Objects

5-Spray inside of tube with "LPS-3" batch: N/A

6-Install blade fitting D3488-041, wearshoe

SIKA FLEX 241

BATCH: 121221EXP DATE: 13/01

7-assemble o'ring to plug as per dwg D3492 and apply o'ring lube

A/R 55-o'ring lube batch: 111 348 1103488-Coat all exposed fasteners with "LPS Procyon" batch: 1145961. RH 2 (2P) 12/05/08

P10

# Dart Aerospace Ltd

W/O: 82791		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D350-636-014 PAR #:          Fault Category: skid tube NCR: Yes ☒ No ☐ DQA:          Date: 12/06/28  
 Resolution:          Disposition: repair QA: N/C Closed:          Date: 12/06/29

NCR: 121539		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12.5.8	230	Found during Assembly that D3488 -041/042 Doesnt Align with skid tube hole RC tol on D3488 -041/042 + Hammer Drill Probes	CP 12 06 04	Drill out 04 15 aft most <del>same</del> hole on skid to max tol  Drill out 04 15 hole to max tol on D3488	CP 12-6-6  CP 12/06/28	CP 12 06 04	CP 12 06 04	CP 12/06/03
			CP 12 06 04	touch up align as per ASI005 + Re assembly.	CP 12 06 04		CP 12 06 04	CP 12/06/03

NOTE: Date & initial all entries



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**\*82791\***

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Item ID: D350-636-014

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**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Skidtube RH

Start Date: 10/04/2012 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 24/04/2012 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: Date:

Run Start **\*NR1\***

QC: Date:

Stop **\*NR2\***

Tooling:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

240

QC5- Inspect part completeness to step on W/O

0.00  
0.00 *8/12/12*

**\*240\***

QC

Memo

Quality Control

250

Pick Kit

0.00

**\*250\***

Packaging

Memo

0.00

Packaging

*K*

*80  
12-6-22*

260

QC4- 100% Inspect kits for completeness

0.00

**\*260\***

QC

Memo

0.00

Quality Control

*/*

*12/12/12*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Start Date: 10/04/2012 Start Qty: 1.00 **\*1\***

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Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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270

**\*270\***

Packaging

Packaging

Packaging

Memo

Package as per PPP D350-636-014

0.00

0.00

*R401*

*Loc 72*

*1X*

*12-6-26*

280

**\*280\***

QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

*12/6/27*

*MF 12-06-26*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
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# Picklist Print

April-10-12 7:55:13 AM

Page 1

Work Order ID: 82791

\*82791\*

Parent Item: D350-636-014

\*D350-636-014\*

Parent Item Name: Skidtube RH

Start Date: 10/04/2012

Required Date: 24/04/2012

Start Qty: 1.00

Required Qty: 1.00

## Comments:

IPP Rev:H02.09.25Rearranged procedure stepsKJ  
 IPP Rev:I05.12.08Rearranged procedure stepsEC  
 IPP Rev:J06.03.30Per rev. D EC  
 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC  
 IPP Rev:M 08-09-23 revF as per dwg DD verified by:ec IPP Rev:N  
 10.06.22 revise seq110 DD verf:EC IPP Rev:O 10.10.01 as  
 per IIN revH DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2600-3-BENT

Manufactured No

110

Each

27.0000

1

\*D2600-3-BFNT\*

B 83305

\*\*

①

9/11

12-04-25

Extrusion Bent

### Location

### Loc Qty

### Loc Code

LG

27

66875

7

73253

1

75021

1

75022

1

75023

1

81330

4

82347

12

D2739

Manufactured No

160

Each

3.0000

1

\*D2739\*

B 83446

\*\*

①

9/11

12-05-01

350 I Beam

### Location

### Loc Qty

### Loc Code

LG

3

72155

1

81508

1

82122

1

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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Work Order ID: 82791

Parent Item: D350-636-014

Parent Item Name: Skidtube RH

\*82791\*

\*D350-636-014\*

Start Date: 10/04/2012

Required Date: 24/04/2012

Start Qty: 1.00

Required Qty: 1.00

D2743

Manufactured No

160 Each

314.0000 8 8

\*D2743\*

Crossbolt Spacer

\*\*

BE 12/05/02  
B81965 x8

## Location

## Loc Qty

## Loc Code

LG001

314

67766

4

68251

3

73403

64

74445

1

78603

2

79517

30

D2744

Manufactured No

160 Each

42.0000 1 1

\*D2744\*

Cap

\*\*

BE 12/04/05

## Location

## Loc Qty

## Loc Code

LG002

42

62715

1

70881

3

78900

38

D3490-1

Manufactured No

160 Each

104.0000 4 4

\*D3490-1\*

Cross Bolt Spacer

\*\*

BE 12/05/02  
B83269 x4

## Location

## Loc Qty

## Loc Code

LG

95

81976

95

LG001

9

62450

2

74875

4

77042

3

April-10-12 7:55:13 AM

Shop Packet Print

Page 2

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



Picklist Print

April-10-12 7:55:13 AM

Work Order ID: 82791

Parent Item: D350-636-014

Parent Item Name: Skidtube RH

\*82791\*

\*D350-636-014\*

Start Date: 10/04/2012

Required Date: 24/04/2012

Start Qty: 1.00

Required Qty: 1.00

D3490-5

Manufactured No

160

Each

45.0000

4

4

\*D3490-5\*

Cross Bolt Spacer

\*\*

BE 12/05/08

Location

Loc Qty

Loc Code

LG

25

78958

25

LG001

20

59230

20

230

Each

2,461.000

38

38

ALS4-1032-225

Purchased

No

\*ALS4-1032-225\*

Insert

\*\*

•

38

DP 12/05/08

Location

Loc Qty

Loc Code

ST281

2438

108696

146

110768

62

118386

55

118966

68

120671

107

121269 ✓

2000

ST282

23

120410

10

120451

13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 82791

Parent Item: D350-636-014

Parent Item Name: Skidtube RH

\*82791\*

\*D350-636-014\*

Start Date: 10/04/2012

Required Date: 24/04/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C5A

Purchased

No

230

Each

1,596.000

34

34

\*AN3C5A\*

Bolt

\*\*

34

OP

12/05/08

Location

Loc Qty

Loc Code

FP001

121444 ✓

7

115835

7

ST350

1589

116419

28

117343

13

117764

7

117872

2

119749

23

120423

516

1210168

500

121255

500

AN3C6A

Purchased

No

230

Each

509.0000

4

4

\*AN3C6A\*

BOLT

\*\*

4

OP

12/05/08

Location

Loc Qty

Loc Code

FP001

1

111982

1

ST351

508

111982

2

116419

23

116549

2

116704

12

117619

10

117688

1

117872

5

118422

13

119449

21

120423

19

120693 ✓

400

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Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 82791

Parent Item: D350-636-014

Parent Item Name: Skidtube RH

\*82791\*

\*D350-636-014\*

Start Date: 10/04/2012

Required Date: 24/04/2012

Start Qty: 1.00

Required Qty: 1.00

AN6C44A

Purchased

No

230

Each

170.0000

4

4

\*AN6C44A\*

BOLT

\*\*

4

(29)

12/05/08

Location

Loc Qty

Loc Code

FG

2

103964

2

ST343

168

120143

25

120465

23

121013

20

121167 ✓

100

AN8C35A

Purchased

No

230

Each

104.0000

1

1

\*AN8C35A\*

BOLT

\*\*

1

(29)

12/05/08

Location

Loc Qty

Loc Code

FP002

103

115960

1

117834

7

118286 ✓

45

121275

50

ST346

1

114442

0

115188

0

115960

1

AN960C10L

✱

NAS1149C0332 R

✓ Purchased

No

230

Each

0.0000

38

38

\*AN960C10I \*

washer

\*\*

38

(29)

12/05/08

121509 ✓

April-10-12 7:55:13 AM

Shop Packet Print

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# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 82791

Parent Item: D350-636-014

Parent Item Name: Skidtube RH

**\*82791\***

**\*D350-636-014\***

Start Date: 10/04/2012

Required Date: 24/04/2012

Start Qty: 1.00

Required Qty: 1.00

D2745

Manufactured No

230

Each

48.0000

8

8

\*\*

8

(2P)

12/05/08

**\*D2745\***

Bushing

Location

Loc Qty

Loc Code

FP

81964✓

46

79518

46

FP001

2

69529

1

76142

1

D3488-042

Manufactured No

230

Each

15.0000

1

1

\*\*

1

(2P)

12/05/08

**\*D3488-042\***

Blade Fitting Assembly, RH

Location

Loc Qty

Loc Code

FP002

82258✓

15

62003

1

75068

8

77015

6

D3492-1

Manufactured No

230

Each

30.0000

8

8

\*\*

8

(2P)

12/05/08

**\*D3492-1\***

Plug

Location

Loc Qty

Loc Code

FP002

83098✓

30

69531

8

74444

2

76235

4

77037

16

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# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

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Work Order ID: 82791

Parent Item: D350-636-014

Parent Item Name: Skidtube RH

\*82791\*

\*D350-636-014\*

Start Date: 10/04/2012

Required Date: 24/04/2012

Start Qty: 1.00

Required Qty: 1.00

D3492-5

Manufactured No

230

Each

72.0000

8

8

\*D3492-5\*

Plug

\*\*

8

(28)

12/05/08

Location

Loc Qty

Loc Code

FP

40

78792 ✓

40

FP002

32

77044

32

D3535-25

Manufactured No

230

Each

22.0000

1

1

\*D3535-25\*

Wearshoe

\*\*

1

(28)

12/05/08

Location

Loc Qty

Loc Code

FP001

22

62233

1

80331

10

81357

11

D3536-25

Manufactured No

230

Each

22.0000

1

1

\*D3536-25\*

Gasket

\*\*

1

(28)

12/05/08

Location

Loc Qty

Loc Code

FP

14

81342

14

FP002

8

78902

8

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**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Page 8

Work Order ID: 82791

Parent Item: D350-636-014

Parent Item Name: Skidtube RH

**\*82791\***

**\*D350-636-014\***

Start Date: 10/04/2012

Required Date: 24/04/2012

Start Qty: 1.00

Required Qty: 1.00

D3537-1

Manufactured No

230 Each

75.0000 3 3

**\*D3537-1\***

Wearpad

\*\*

3

28

12/05/08

Location

Loc Qty

Loc Code

FG

81362✓

10

79833

10

FP002

65

69817

5

80337

11

81361

49

D3631-1

Manufactured No

230 Each

227.0000 8 8

**\*D3631-1\***

Washer

\*\*

8

28

12/05/08

Location

Loc Qty

Loc Code

FG

83588✓

100

81874

100

ST072

127

68062

2

75548

125

D3672-1

Manufactured No

230 Each

1,022.000 8 8

**\*D3672-1\***

Phenolic Washer

\*\*

8

80126-22

Location

Loc Qty

Loc Code

FP001

34

66821

34

ST060

988

72229

4

76277

484

80369

500

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 82791

Parent Item: D350-636-014

Parent Item Name: Skidtube RH

\*82791\*

\*D350-636-014\*

Start Date: 10/04/2012

Required Date: 24/04/2012

Start Qty: 1.00

Required Qty: 1.00

D3791-1

Manufactured No

230

Each

25.0000

1

1

\*D3791-1\*

Wearplate

\*\*

(28)

12/05/08

Location

Loc Qty

Loc Code

FP002

83392 ✓

25

62239

2

78897

7

82168

16

D3793-1

Manufactured No

230

Each

26.0000

1

1

\*D3793-1\*

Wearshoe

\*\*

1

(28)

12/05/08

Location

Loc Qty

Loc Code

FP001

83393 ✓

26

78901

10

82171

16

D3793-3

Manufactured No

230

Each

30.0000

1

1

\*D3793-3\*

Wearshoe

\*\*

1

(28)

12/05/08

Location

Loc Qty

Loc Code

FP001

23

80434

11

82166 ✓

12

FP002

7

78935

7

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**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Page 10

Work Order ID: 82791

Parent Item: D350-636-014

Parent Item Name: Skidtube RH

\*82791\*

\*D350-636-014\*

Start Date: 10/04/2012

Required Date: 24/04/2012

Start Qty: 1.00

Required Qty: 1.00

D3794-1

Manufactured No

230

Each

39.0000

1

1

\*D3794-1\*

Gasket

\*\*

1 (2P) 12/05/08

Location

Loc Qty

Loc Code

FP

23

82167 ✓

23

FP002

16

75042

4

80435

12

D3794-3

Manufactured No

230

Each

23.0000

1

1

\*D3794-3\*

Gasket

\*\*

1 (2P) 12/05/08

Location

Loc Qty

Loc Code

FP002

23

83396 ✓

2

74530

21

80436

MS21043-6

Purchased No

230

Each

765.0000

4

4

\*MS21043-6\*

NUT

\*\*

4 (2P) 12/05/08

Location

Loc Qty

Loc Code

FG

20

103693

20

ST301

745

112314

39

117887

6

118384 ✓

200

120308

500

April-10-12 7:55:13 AM

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**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



Picklist Print

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Work Order ID: 82791

Parent Item: D350-636-014

Parent Item Name: Skidtube RH

\*82791\*

\*D350-636-014\*

Start Date: 10/04/2012

Required Date: 24/04/2012

Start Qty: 1.00

Required Qty: 1.00

MS21083C8

Purchased

No

230

Each

105.0000

1

1

\*MS21083C8\*

NUT

\*\*

2P 12/05/08

Location

Loc Qty

Loc Code

304

50

121185 ✓

50

FP002

1

115884

1

ST303

5

115884

0

118077

1

119309

2

119638

2

ST304

49

120142

7

120731

17

121011

25

NAS1149C0832R

Purchased

No

230

Each

293.0000

1

1

\*NAS1149C0832R\*

WASHER

\*\*

1 2P 12/05/08

Location

Loc Qty

Loc Code

ST297

293

114915 ✓

293

April-10-12 7:55:13 AM

Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 82791

Parent Item: D350-636-014

Parent Item Name: Skidtube RH

\*82791\*

\*D350-636-014\*

Start Date: 10/04/2012

Required Date: 24/04/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1515H3L

Purchased

No

230

Each

190.0000

4

4

**\*NAS1515H3I \***

WASHER

\*\*

4

2P

12/05/08

Location

Loc Qty

Loc Code

FG

40

102472

40

ST277

150

118686

3

119438

1

120360

96

121243 ✓

50

NAS1611-005

Purchased

No

230

Each

204.0000

8

8

**\*NAS1611-005\***

O-RING

\*\*

8

2P

12/05/08

Location

Loc Qty

Loc Code

FP001

204

106099

31

114220 ✓

105

119438

68

April-10-12 7:55:13 AM

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# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Picklist Print

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Work Order ID: 82791

Parent Item: D350-636-014

Parent Item Name: Skidtube RH

\*82791\*

\*D350-636-014\*

Start Date: 10/04/2012

Required Date: 24/04/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1611-010

Purchased

No

230

Each

259.0000

8

8

\*\*

8

SP

12/05/08

\*NAS1611-010\*

O-RING

Location

Loc Qty

Loc Code

FP

121415

50

110915

0

120770

50

FP001

209

110915

14

117460

8

118077

1

118612

3

119438

47

120986

50

121166

36

121259

50

AN8C21A

Purchased

No

250

Each

121.0000

2

2

\*\*

SP 12-6-22

\*AN8C21A\*

BOLT

Location

Loc Qty

Loc Code

ST343

121

118758

5

120094

26

121067

20

121167

20

121275

50

2x

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 82791

Parent Item: D350-636-014

Parent Item Name: Skidtube RH

\*82791\*

\*D350-636-014\*

Start Date: 10/04/2012

Required Date: 24/04/2012

Start Qty: 1.00

Required Qty: 1.00

D2741

Manufactured No

250

Each

63.0000

1

1

\*D2741\*

Blade, 350 Skidtube

\*\*

SP

Location

Loc Qty

Loc Code

ST

-10

ST466

73

71856

1

76984

22

79516

40

\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_  
IX

D3493-1

Manufactured No

250

Each

46.0000

2

2

\*D3493-1\*

Washer

\*\*

BS2023 SP

12-6-22

Location

Loc Qty

Loc Code

ST050

46

70697

2

77573

4

78835

40

\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_

April-10-12 7:55:13 AM

Shop Packet Print

Page 14

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

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Page 15

Work Order ID: 82791

Parent Item: D350-636-014

Parent Item Name: Skidtube RH

\*82791\*

\*D350-636-014\*

Start Date: 10/04/2012

Required Date: 24/04/2012

Start Qty: 1.00

Required Qty: 1.00

MS21083C8

Purchased

No

250

Each

105.0000

2

2

\*MS21083C8\*

NUT

\*\*

m/21349 SP

## Location

## Loc Qty

## Loc Code

304

50

121185

50

FP002

1

115884

1

ST303

5

115884

0

118077

1

119309

2

119638

2

ST304

49

120142

7

120731

17

121011

25

NAS1149D0863J

Purchased

No

250

Each

211.0000

2

2

\*NAS1149D0863J\*

WASHER

\*\*

12-622

## Location

## Loc Qty

## Loc Code

ST298

211

118078

36

119307

75

120308

100

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Page 15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1			D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

# GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH:  
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.  
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ( $\phi 0.297$ ) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:  
MINIMUM YIELD TENSILE STRENGTH = 35 KSI  
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.  
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS OFF  
POWDER COATING WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

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NO. 02791 MCT  
12/04/10

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F	INCORPORATE DSI 9413, QTY (3) D3537-1 WAS, QTY (5) (ZN C8-1), D3791-1/-3 REPLACES D3536-13/-35 (ZN C8-1), D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1), ADD D3791-1 (ZN C8-1), WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL), WEARSHOE HARDWARE QTY UPDATED (ZN B8-1), D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11), ADD NOTE 12 AND 13 (ZN A6-1), REASON REF. NCR 08-043	PH	08 07 16
E	CHANGE TO STAINLESS STEEL WEARPLATES, ADD RUBBER GASKETS, CHANGE INSERTS, ADD D3631-1, REMOVE QTY (38) NAS1515H3L, REMOVE QTY (10) NAS1515H8L, REMOVE D2741, QTY (2) AN960C816, REMOVE QTY (2) MS21083C8	CB	07 05 17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS, INCORPORATE DEO 9133/9157	PH	06 01 05
C	ADD D2750-3/D2750-4, INCORPORATE D2738 AND D2740	CP	98 11 18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.07.16		

DART AEROSPACE USA, INC.	
PORT HADLOCK, WA	
DRAWING NO.	REV. F
D2750	SHEET 1 OF 11
TITLE	SCALE
350 SKIDTUBE ASSEMBLY	NTS
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**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

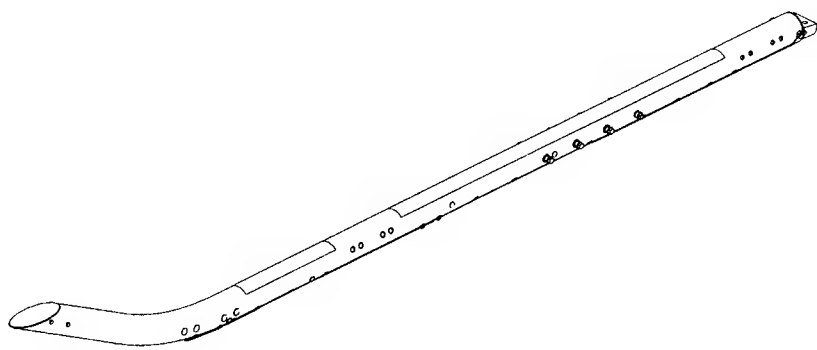
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

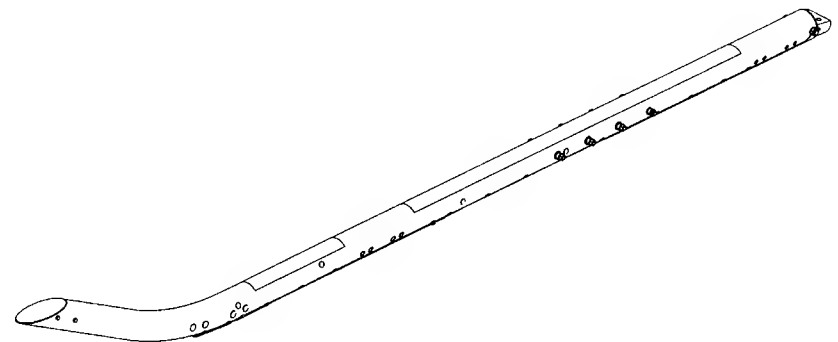
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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D2750-041 350 SKIDTUBE ASSEMBLY, LH



D2750-042 350 SKIDTUBE ASSEMBLY, RH

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158-9227/11

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DRAWN	PA	PORT HADLOCK, WA	
CHECKED	PA	DRAWING NO	REV. F
MFG. APPR	PA	<b>D2750</b>	SHEET 2 OF 11
APPROVED	ME	TITLE	SCALE
DE APPR.	PA	<b>350 SKIDTUBE ASSEMBLY</b>	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

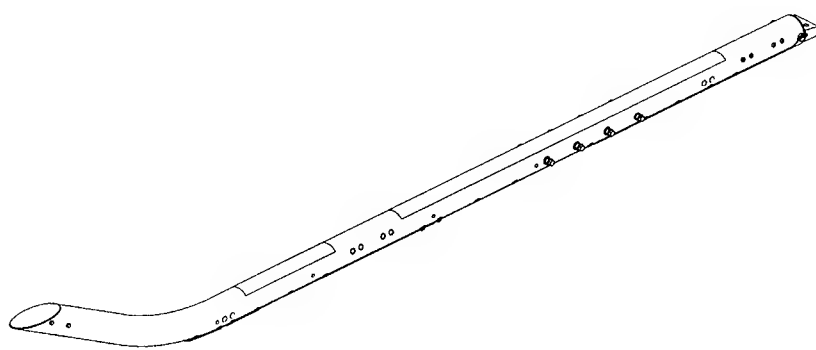
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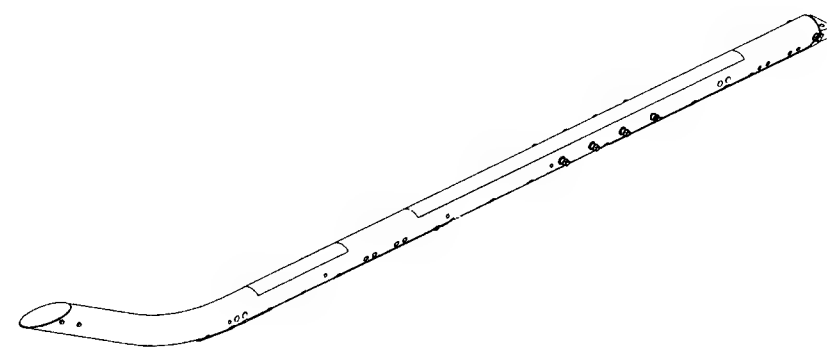
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

02791



D2750-043 350 SKIDTUBE ASSEMBLY, LH



D2750-044 350 SKIDTUBE ASSEMBLY, RH

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68-9-22/11

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CHECKED	DA	DRAWING NO	REV. F
MFG. APPR	DA	D2750	SHEET 3 OF 11
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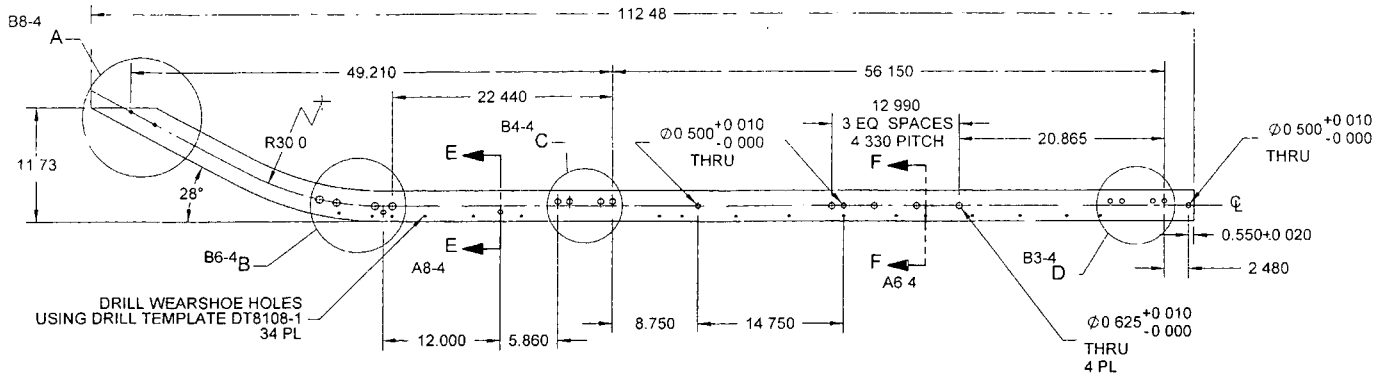
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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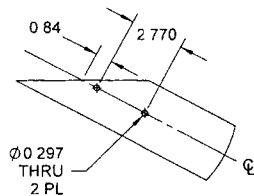
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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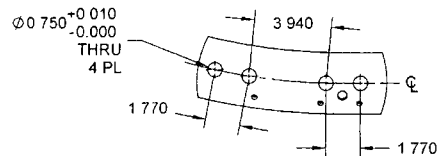




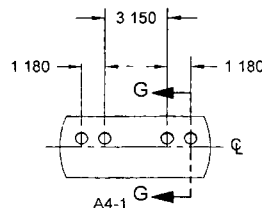
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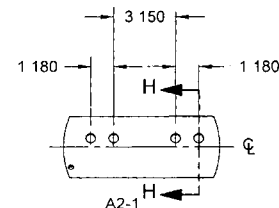
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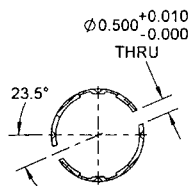
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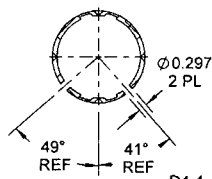
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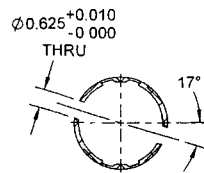
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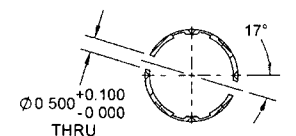
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SCALE 3X, 2 PL



**SECTION F-F**  
SCALE 3X, 17 PL



**SECTION G-G**  
SCALE 3X, 4 PL



**SECTION H-H**  
SCALE 3X, 4 PL

DESIGN	1/1	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	1/1	PORT HADLOCK, WA	
CHECKED	1/1	DRAWING NO	REV F
MFG. APPR.	1/1	D2750	SHEET 4 OF 11
APPROVED	1/1	TITLE	SCALE
DE APPR	1/1	350 SKIDTUBE ASSEMBLY	NTS
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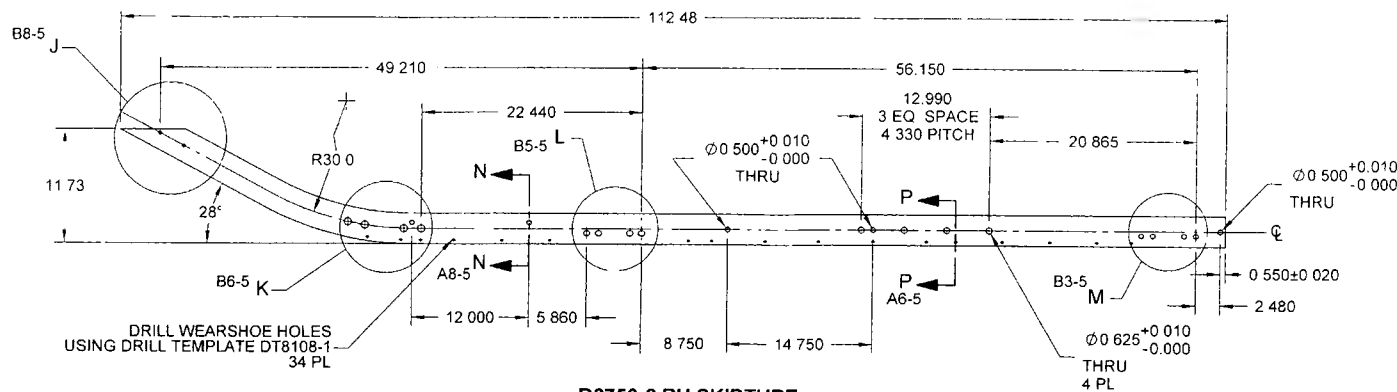
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

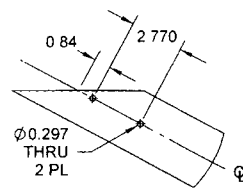
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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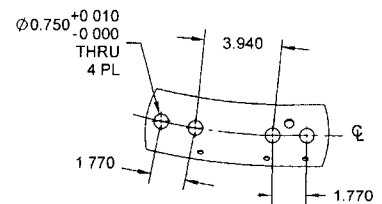
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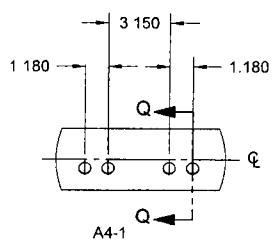
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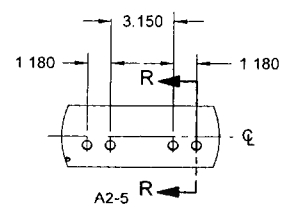
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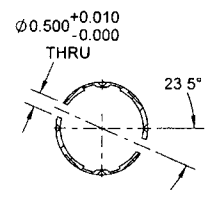
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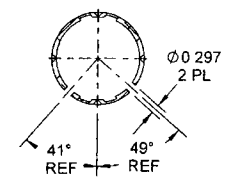
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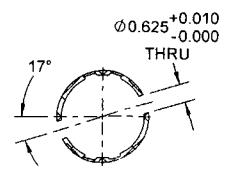
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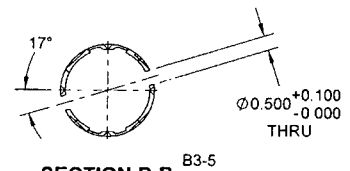
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SCALE 3X, 2 PL



**SECTION P-P**  
SCALE 3X, 17 PL



**SECTION Q-Q**  
SCALE 3X, 4 PL



**SECTION R-R**  
SCALE 3X, 4 PL

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DESIGN	PEL	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	PEL	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR		<b>D2750</b>	SHEET 5 OF 11
APPROVED		TITLE	SCALE
DE APPR		<b>350 SKIDTUBE ASSEMBLY</b>	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

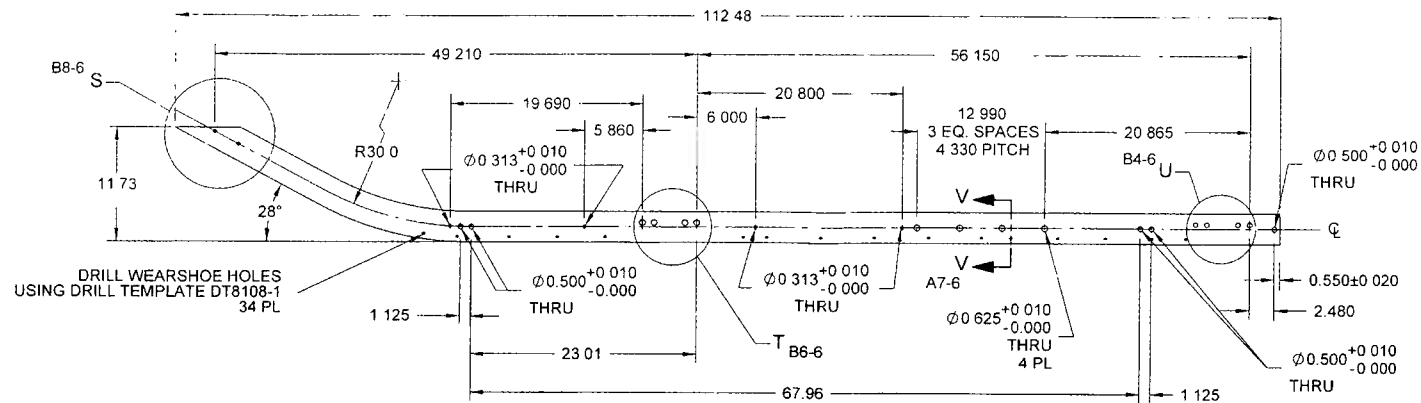
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

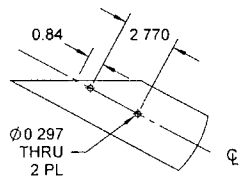
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

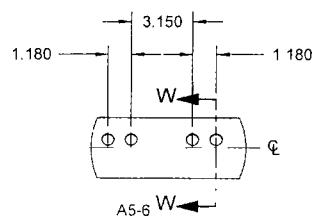
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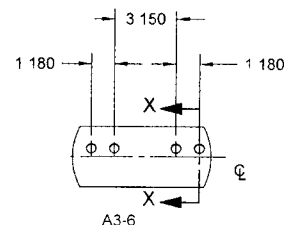
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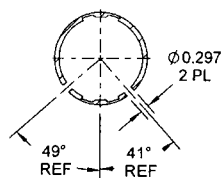
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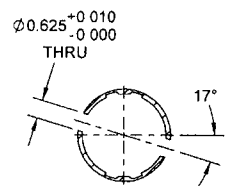
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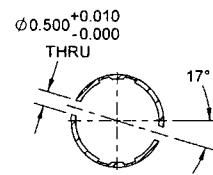
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SCALE 2X



**SECTION V-V**  
SCALE 3X, 17 PL



**SECTION W-W**  
SCALE 3X, 4 PL



**SECTION X-X**  
SCALE 3X, 4 PL

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DESIGN	PA	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	PA	PORT HADLOCK, WA	
CHECKED		DRAWING NO	REV. F
MFG APPR.		<b>D2750</b>	SHEET 8 OF 11
APPROVED		TITLE	SCALE
DE APPR		<b>350 SKIDTUBE ASSEMBLY</b>	NTS
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# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

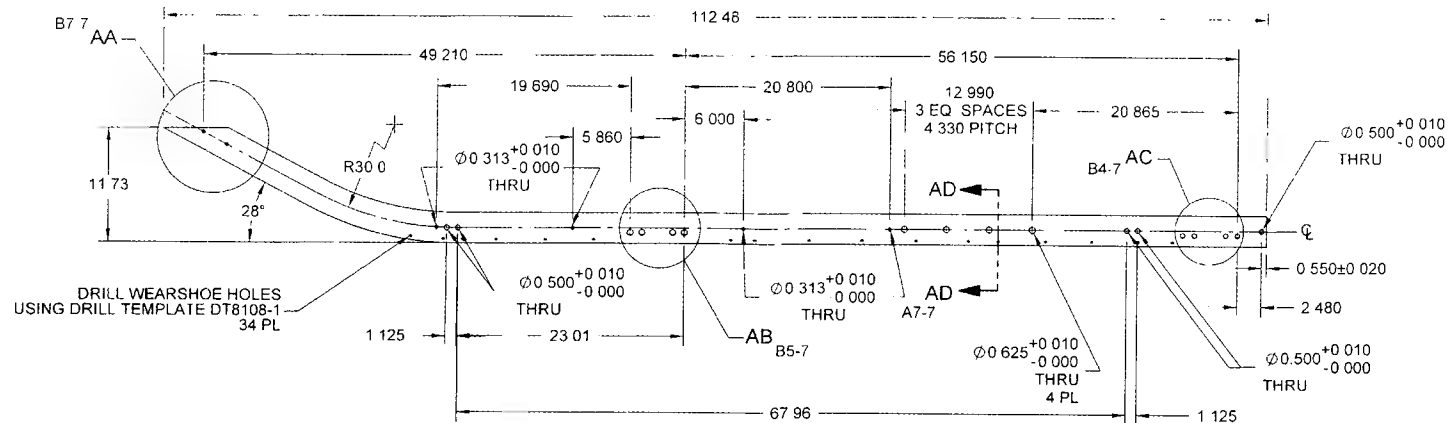
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

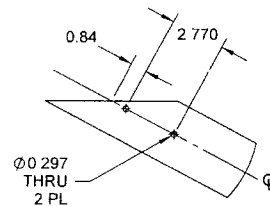
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

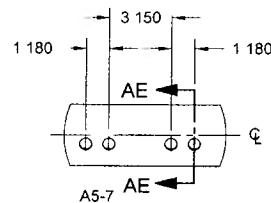
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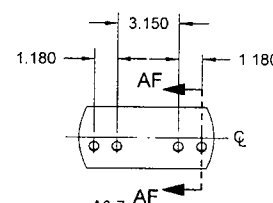
**D2750-4 RH SKIDTUBE**



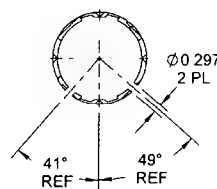
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SCALE 2X  
D7-7



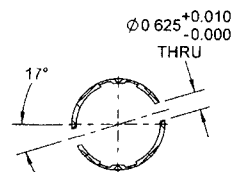
**DETAIL AB**  
SCALE 2X  
C4-7



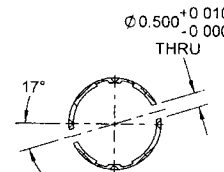
**DETAIL AC**  
SCALE 2X  
D3-7



**SECTION AD-AD**  
SCALE 3X, 17 PL  
D3-7



**SECTION AE-AE**  
SCALE 3X, 4 PL  
B6-7



**SECTION AF-AF**  
SCALE 3X, 4 PL  
B4-7

RELEASED  
08-09-2013

DESIGN	REV F	<b>DART AEROSPACE USA, INC.</b>
DRAWN	REV F	PORT HADLOCK, WA
CHECKED	REV F	DRAWING NO
MFG. APPR.	REV F	<b>D2750</b>
APPROVED	REV F	TITLE
DE APPR.	REV F	<b>350 SKIDTUBE ASSEMBLY</b>
DATE	08.07.16	SCALE
		NTS

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## WORK ORDER CHANGES

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

## WORK ORDER NON-CONFORMANCE (NCR)

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

NO. 293

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barclay Elliott  
Job number: 82796  
Part number: A350-636-014  
Description: Skid tube  
Welding Process: Tig[☒] Mig[ ]  
Base material: Alum  
Current: AC[☒] DC[ ]

TEST REQUIREMENTS AND RESULTS

Visual:

pass[☒] fail[ ]

Penetration:

pass[☒] fail[ ]

UNACCEPTABLE

Cracks:

pass[☒] fail[ ]

Undercut:

pass[☒] fail[ ]

Pin holes:

pass[☒] fail[ ]

Overlap (cold lap)

pass[☒] fail[ ]

Porosity (surface):

pass[☒] fail[ ]

Coloration:

pass[☒] fail[ ]

Qualifier David Reed Date of Test Coupon 12-05-01

Welder Barclay Elliott Date of Test Coupon 12-05-01

The above named individual is qualified in accordance with AWS D17.1.2001 to weld



